

Date: Thursday, 3/22/2007 2:41:46 PM
User: Kim Johnston

ASAP HS

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ANGLE
Job Number	: 31441		
Estimate Number	: 10198		
P.O. Number	: N/A	Part Number	: D21752
This Issue	: 3/22/2007 S.O. No. : N/A	Drawing Number	: D2175 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: E
Previous Run	: 26496	Material	: N/A
		Due Date	: 3/30/2007
Written By	:	Qty:	39
Checked & Approved By	: <u>07.03.22</u>	Um:	40
Comment	:	Each	
	: Est E 04.06.09 Reformat KJ/RF		
	: Est Rev:F 06-04-28 Manufactured on Water Jet JLM		
	: Est Rev:G As per Rev E 06-11-22 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.4958 sf(s)/Unit Total : 19.8324 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.063" thick
(M2024T3S.063) Batch: 4103321

07.03.26

(39)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D2175
Dwg Rev: E
Prog Rev: E

07.03.26

(39)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07.03.26

(39)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07.03.28

(39)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr Stack

07.03.28

(39)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/03/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 31441

Part Number: D21752

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2175

SB 07/03/29

(39)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-03-29

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

UL

07-03-29

(39)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

813

07/03/29

(39)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

813

07/03/29

(39)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2

07/03/30

(39)

Job Completion:



UL 07-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

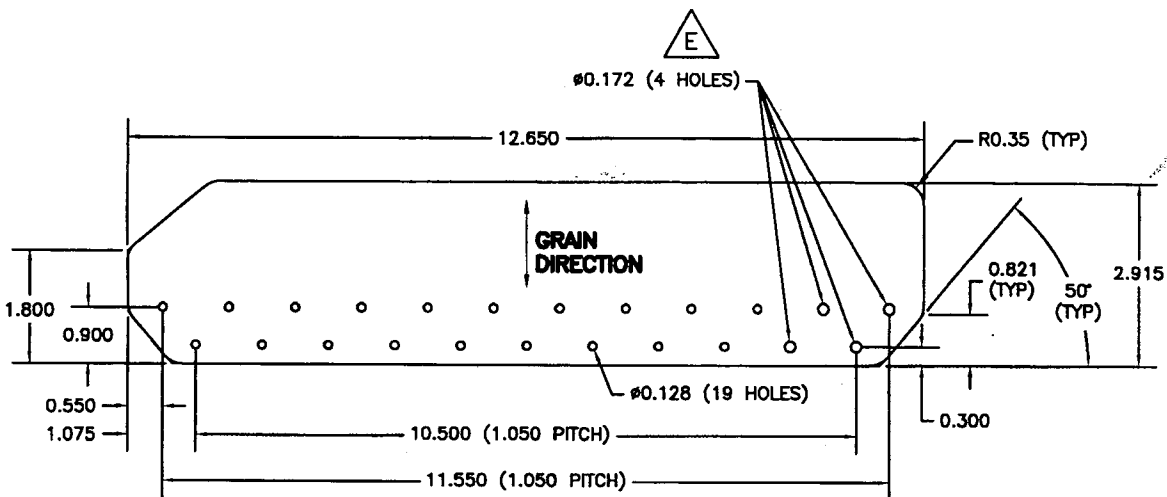
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

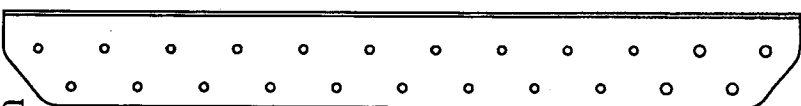


RELEASED
06.10.13

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		
RF	CE	DRAWING NO.	REV. E	
CHECKED PH	APPROVED [Signature]	D2175	SHEET 1 OF 1	
DATE 06.09.25	TITLE ANGLE	SCALE 1:3		
A	95.10.25	NEW ISSUE		
B	96.01.18	CHANGED DIMENSION		
C	00.09.11	UPDATE FINISH SPEC		
D	04.06.03	RE-DESIGN		
E	06.09.25	INC HOLE DIA TO Ø0.172, 4 HOLES		



D2175-1F FLAT PATTERN



**D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)**

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 31441

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